

5/42

DART AEROSPACE LTD	Work Order:	24401
Description: Bushing	Part Number:	D2617-5
Dwg: D2617 Rev. D1 D2	Qty:	50
05.10.03 <i>Posing</i>		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>HJ</i>	05.10.04	50
2	MC	Machine as per Folio FA438 and Dwg D2617 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall (M6061T6T0.500W.058) Identify as D2617-5 Batch: <u>M18740</u>	<i>J.G.</i>	05/10/27	50
3	QC2	Inspect parts as they come off the CNC machine	<i>J.G.</i>	05/10/27	50
4	QC8	Second check	<i>BB</i>	05.10.28	50
5	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	<i>J.G.</i>	05/10/28	50
6	FP	Acid Etch and Alodine as per QSI 005 4.1	<i>SAD</i>	05/11/17	50
7	QC3	Inspect work to Step 6	<i>CL</i>	05/11/24	50
8	ST	Identify and Stock <i>Loc: 49</i>	<i>CL</i>	05/11/24	50
9	AC	Cost / part: _____	<i>SUR</i>	05.11.25	50
10	DC	Close W/O Inspect Level 21	<i>LD</i>	05/11/25	50

Rev	Date	Change	Revised By	Approved
D	98.04.16	Re-Format	KB	
E	99.08.23	Re-format, added notes and inspection level	EC	
F	01.01.03	Re-format, made in-house	EC	
G	01.01.08	Updated material NCR 467	EC	
H	04.07.14	Reformat; added step 5	KJ/JLM	<i>[Signature]</i>

RELEASED

[Signature] 05.07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 05/01/25

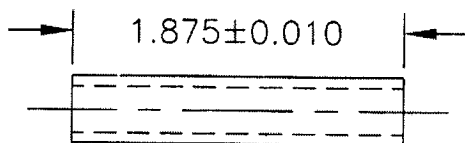
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

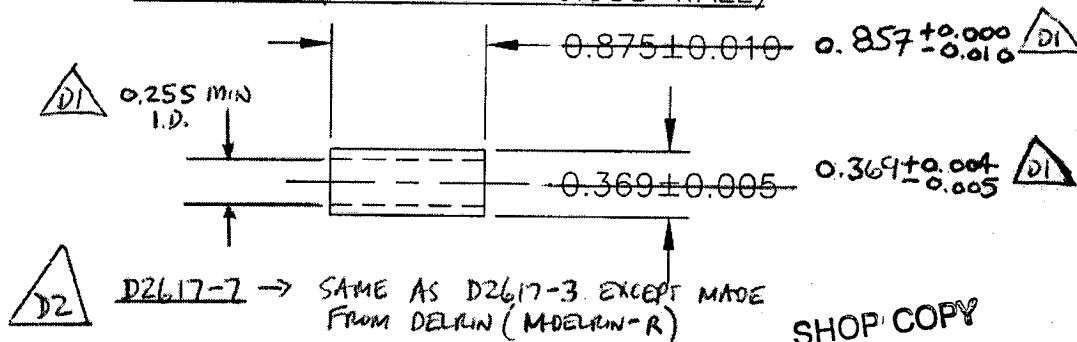


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING	SCALE 1:1
DZ	04.09.10	#	CP	ADD D2617-7	
A	96.10.08			NEW ISSUE	
B	97.05.08			.875 WAS 1.125	
C	97.06.04			0.369 DIA WAS 0.375	
D	01.07.04			ADD MAT'L SPEC AND TOL./DIM. NOTE	
DI	CP	04.07.12	#	CORRECT TOLERANCE (NCR 779)	

D2617-1 (0.375 OD x 0.058 WALL)

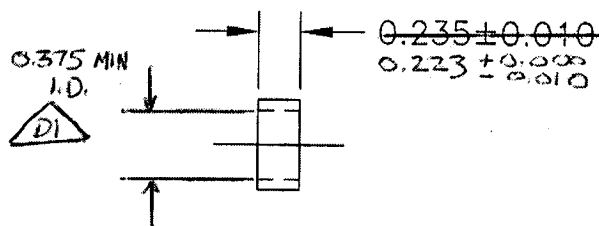


D2617-3 (0.375 OD x 0.058 WALL)



DZ D2617-7 → SAME AS D2617-3 EXCEPT MADE FROM DELRIN (MDELRIN-R)

D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24401

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 03, 2005
11:23 am

Work Order No : 0024401
Project Name : D2617-5
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D2617-5
Description : Spacer
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 10-03-05
Est Finish Date : 10-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00